

Work Order ID 127579

Monday, March 23, 2015 10:50:10 AM

127579

Reprint

Page 1

Item ID: D2274

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Radius Block

Start Date: 12/8/2014 Start Qty: 300.00

300

Cust Item ID:

Required Date: 12/17/2014 Req'd Qty: 300.00

300

Customer:

Reference:

Approvals: Process Plan: *MJS*

Date: *15-03-23* Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2274	Rev F								
100		0.00							
100	SHEAR								
Shear	Memo	0.00							
Shear	blanks 9.00" long +/- 0.030"								
	Note: 1 blank makes 9 pieces								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per folio D2274								
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

57

Ø

FL 15/03/25

530

Ø

DAS
20
9-89

15-03-27

530

Ø

DAS
20
9-89

15-03-27

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Item ID: D2274

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Radius Block

Start Date: 12/8/2014 Start Qty: 300.00

300

Cust Item ID:

Required Date: 12/17/2014 Req'd Qty: 300.00

300

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

530 $\emptyset$ 9/15/03/30

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

TumbleDeburr any rough edges after tumbling

Start 7.20am
Finish 3.45pm

530x DAS 28 MAR 30 2015
530x 9.80
D3E 15-3-31
530x Del 15-3-31

150

Chemical Conversion Coat per QS1005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

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Page 3

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Item ID: D2274

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Radius Block

Start Date: 12/8/2014 Start Qty: 300.00

300

Cust Item ID:

Required Date: 12/17/2014 Req'd Qty: 300.00

300

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

530

38
9-89

APR 01 2015

170

Identify as per dwg & Stock Location: Stop

0.00

170

Packaging

Memo

0.00

Packaging

S36

DAS
27
8-88
APR 02 2015

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 15-04-02

15-4-2

Picklist Print

Monday, March 23, 2015 10:50:17 AM

Page 1

Work Order ID: 127579

127579

Parent Item: D2274

D2274

Parent Item Name: Radius Block

Start Date: 12/8/2014

Required Date: 12/17/2014

Start Qty: 300.00

Required Qty: 300.00

Comments: IPP H00.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	104.8500	0.0916	28.92633			

M6061T6B00750X00 125

6061-T6 Bar .750 x .125

**

DAS
44
9-89

1803/25

Location	Loc Qty	Loc Code
MAT	80	
✶ M131653	80	
MAT001	24.85	
M127818	20.3	
M129167	4.55	

21.75'

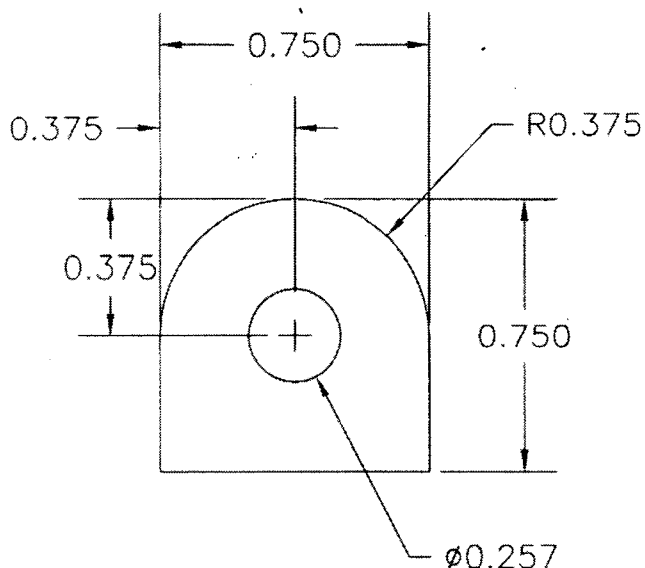
25'

Could not pull mat!!



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/13 KE



121579 M45
1503-23

EC 00.05.16
00.05.16

0.063 x 45° CHAMFER
R0.0 - 0.13

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED